

Patent claims

1. A process for producing hot-rolled aluminum strip for can making, especially in rolling plant whose yearly production capacity is below 250,000 tons, having a reversing roughing stage for the feed material, which is used hot, and immediately thereafter finishing rolling of the strip, which is followed by heat treatment of the strip coiled up into coils, wherein, during the last finishing rolling passes, recrystallization in the rolled material is suppressed by means of controlled temperature management of the hot strip and the recrystallization is specifically brought about outside the rolling train, directly following the finishing rolling.
2. The process for producing hot-rolled aluminum strip for can making as claimed in claim 1, wherein the last, preferably three, hot rolling passes in the finishing rolling are carried out without recrystallization on a reversing roll stand from coil to coil in the noncritical temperature range from 260°C to 280°C, and, immediately thereafter and utilizing the rolling heat, each coiled finished coil is fed to a continuous pusher-type furnace for coils, in which the finished coils are heated to recrystallization temperature (315°/320°).
3. A plant for carrying out a process for producing hot-rolled aluminum strip for can making, especially in

rolling plant whose yearly production capacity is below 250,000 tons, having a reversing roughing stage for the feed material, which is used hot, and immediately thereafter finishing rolling, which is followed by heat treatment of the strip coiled up into coils, wherein the finishing rolling is carried out on a four-high reversing roll stand (2) with winding devices (8, 9) arranged on both sides, wherein one of the winding devices (9) corresponds to a coil transport device (10) for the finished coil and, on the other side, is connected to the continuous pusher-type coil furnace (3), into which the coil (B) can be introduced.

4. The plant for carrying out a process for producing hot-rolled aluminum strip for can making as claimed in claim 3, wherein the continuous pusher-type coil furnace (3) is equipped with a pallet transport system in which a number of pallets (11) in contact with one another hold the coils (B), which can be transported through the continuous pusher-type coil furnace (3) by displacing the pallets (11).

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